

Date: Monday, 20/04/2009 12:59:59 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 47292			Part Number	: D2877	
Estimate Number	: 10827			Drawing Number	: D2877 REV B	
P.O. Number	:			Project Number	: N/A	
This Issue	: 20/04/2009		S.O. No. :	Drawing Revision	: B	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	SMALL /MED FAB	Due Date	: 10/05/2009 Qty: 120 Um: Each
Previous Run	: 46518					
Written By	:					
Checked & Approved By	: <u>Jul 09.04.20</u>					
Comment	: Est B 00.05.19 Added inspect level 8 EC Est C 06.04.26 Water jet EC Est Rev:D Now M6061-T6 06-06-23 JLM Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S125	6061-T6 .125 Sheet	
		Comment: Qty.: 0.0637 sf(s)/Unit Total : 7.6482 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.125" Thick Batch: <u>10067</u> <u>RB 9-5-6</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2877 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <u>RB 9-5-6</u>	
		2- deburr <u>RB 9-5-6</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		Deburr if necessary	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(x120)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Cmp / BL

09/05/11

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(120)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F/L 09/05/11

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: ST53

AS 09/05/12 (x120)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 ff

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	47292
Description: Saddle Spacer	Part Number:	D2877
Inspection Dwg: D2877	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	PB	Audited by:	S	Prototype Approval:	N/A
Date:	9-5-6	Date:	9/10/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2877
PH	MM	REV. B SHEET 1 OF 1
DATE		TITLE SCALE
06.05.17		SADDLE SPACER 1:1
A	99.02.23	NEW ISSUE
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE

**RELEASED**  
*(06.06.21)*AS PER ECOV 813  
*SM*

R0.44 (TYP 2 PLACES)

0.98

R0.06  
(TYP. 4 PLACES)

Ø0.257 (TYP)

R0.30  
(TYP)

3.36 2.358

1.179

R0.88

1.00

R0.40  
(TYP)

0.555

0.250<sup>+0.030</sup><sub>-0.000</sub> (TYP)

0.542

1.370

2.36

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK  
(REF DART SPEC M6061T6S.125)  
OR  
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK  
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. H1292

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